

# Work Order ID 65569

January 19, 2011 2:37:09 PM



Page 1

Item ID:	D2855	Accept		Setup	Start	
Revision ID:						
Item Name:	Cap				Stop	
Start Date:	1/19/11	Start Qty: 35.00		Cust Item ID:		
Required Date:	2/07/11	Req'd Qty: 35.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>1/10/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2855	Rev A								

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>13320</u> <input type="checkbox"/> Cast per Dwg D2855 <input type="checkbox"/> Material Release Note Required								

CL 1/10/11 (35)

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

1/11/11 (30)

120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									

Sub 2101

count  
(35)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65569

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Page 2

Item ID: D2855

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 1/19/11

Start Qty: 35.00

Cust Item ID:

Required Date: 2/07/11

Req'd Qty: 35.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT8235 □2- Open holes to 19/64" □3- Deburr

⇒ m. k 11/02/07

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.12.08

counted  
35

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

m 11595L

Memo

0.00

Powder Coating

START TIME:

1:35

OVEN TEMPERATURE:

FINISH TIME:

2:05

35 11-02-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65569

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Item ID: D2855

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 1/19/11

Start Qty: 35.00



Cust Item ID:

Required Date: 2/07/11

Req'd Qty: 35.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

35 0 JL 11/02/23

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

x35 0 JL 11/02/23

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Swl 02/23

count  
x35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65569

January 19, 2011 2:37:09 PM



Page 4

Item ID: D2855

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 1/19/11

Start Qty: 35.00



Cust Item ID:

Required Date: 2/07/11

Req'd Qty: 35.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: F12-0

0.00



Packaging

Memo

0.00

Packaging

X35 6 JH 11/02/23

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 JH

MF

11-02-23

# Picklist Print

Page 1

January 19, 2011 2:37:09 PM

Work Order ID: 65569

Parent Item: D2855

Parent Item Name: Cap



Start Date: 1/19/11

Required Date: 2/07/11

Start Qty: 35.00

Required Qty: 35.00

Comments: IPP: B000.06.22 Added receiving step & removed P/O for powder coat  
EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225		Purchased	No			100	Each	700.0000	2	70			
INSERT													

## Location

## Loc Qty

## Loc Code

ST282

700

M110768

100896

100

X70

111529

300

111581

300

D2855P

Purchased

No

170

Each

0.0000

1



Cap



35  
1/19/11 (35)



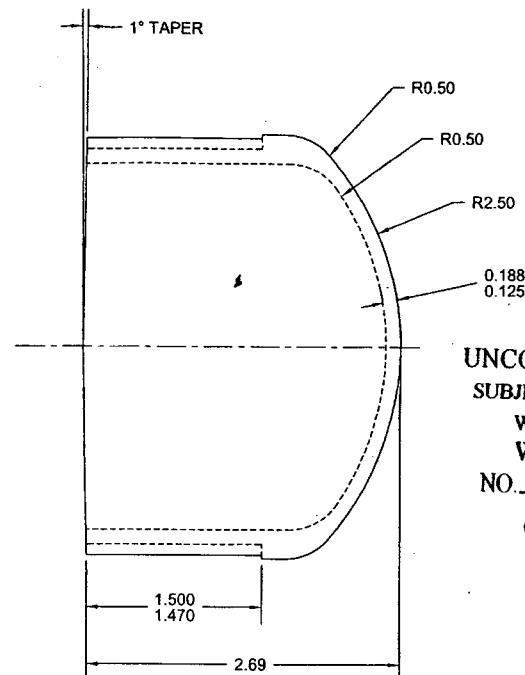
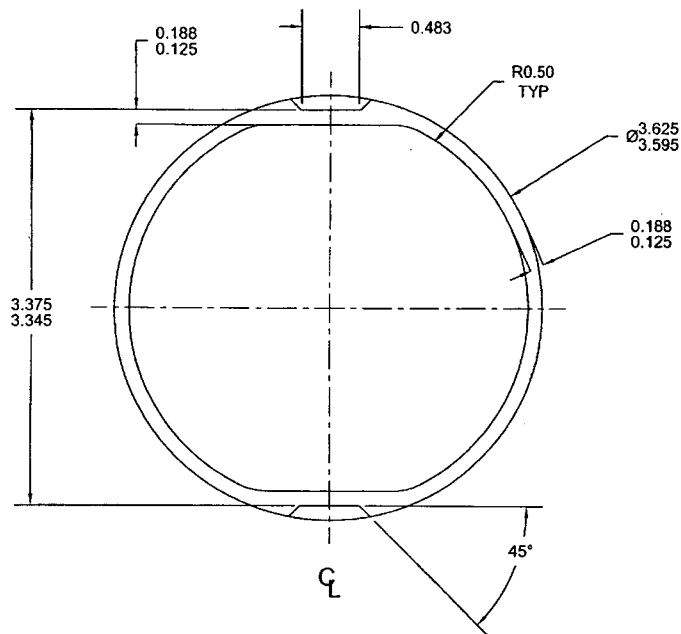
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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WORK ORDER  
NO. 65569  
CL 11/10/19

D2855C CASTING DETAIL



RELEASED  
09/10/19

**NOTES:**

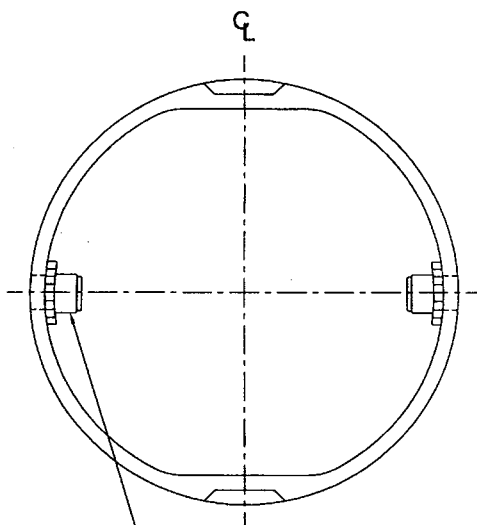
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

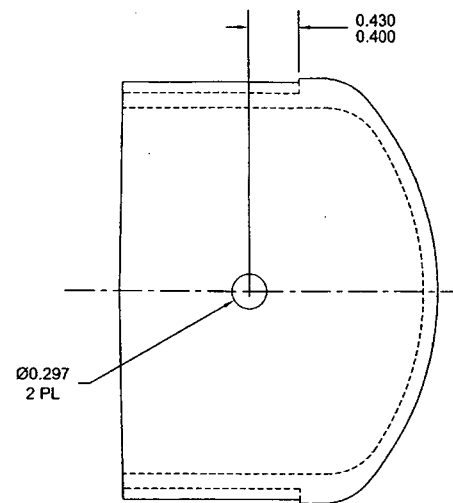
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2855	REV. B SHEET 1 OF 3
TITLE CAP	SCALE NTS

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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL



Ø0.297  
2 PL

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WORK ORDER  
NO. 65569

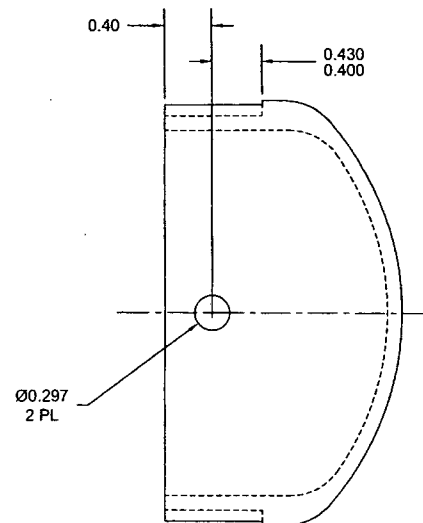
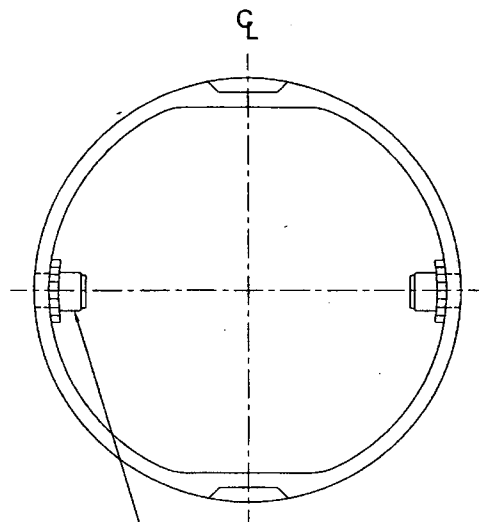
**D2855 CAP**  
(MAKE FROM D2855C CASTING)

**RELEASED**  
31/15 MP


**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

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WITHOUT NOTICE  
WORK ORDER  
NO. 65369

**RELEASED**  
*29/7/15*

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 3 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13320

Purchase Order Date 1/19/11

PO Print Date 1/19/11

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.  
2225 CHEMIN ST. FRANCOIS  
DORVAL, QC H9P 1K3  
CA

Contact Name

Vendor Phone 514 683 9777

Vendor Fax 514 683 0375

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

REMOVED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
CL 1/19/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	2/07/11 Yes	15.00 Each	FedEx PI collect	\$18.1000	\$271.50
		Special Inst:	AS PER DWG D2855 REV. A B65519 MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)				
2	D2855P	Cap	2/07/11 Yes	35.00 Each	FedEx PI collect	\$18.1000	\$633.50
		Special Inst:	AS ABOVE B65569				
PO Total:							\$905.00

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 3

Change Date: 1/19/11

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# Aluminum Foundry Ltd

2225 Chemin St. Francois

Dorval, Québec H9P 1K3

Tel: (514) 683-9777

Fax: (514) 683-0375

email: info@foundryafpw.com

## Packing Slip

Packing Slip No.:

33599

Shipped Date:

01 26 11

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7  Tel. (613) 632-5200 Fax (613) 632-5246	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 13320	
<b>Shipped By:</b> Fedex collect	
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A  Subtotal x 35 pcs	50  (35)
Received by:			
Date:			
Comment:			

Alu. Chantal

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à  
Shipped

DART AEROSPACE

A.F. &amp; P.W.Série no./Serial no.

1270 Aberdeen Street

Packing  
Date: 26/01/2011 Slip No. 33214

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 10794

Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
50pcs	D 2855 CAP  8 116001 x 35 pes	Z098046	A356.2	ingot#C6250541 B#11025001
Analyse Analysis (as In Ingot)				
(Si)	6.90% (Al) balance			
(Fe)	0.11%			
(Cu)	<0.01%			
(Mn)	<0.01%			
(Mg)	0.38%			
(Zn)	<0.01%			
(Ti)	0.11%			
Donne Yield:	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de  
For and on behalf of:FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100